

Date: Tuesday, 1/23/2007 7:31:57 AM
User: Kim Johnston

Process Sheet

Split 2027

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 30381-1
Estimate Number : 10267
P.O. Number : N/A
This Issue : 1/23/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : PURCHASED PARTS
Previous Run : 28732
Written By :
Checked & Approved By : 07.01.23
Comment : Est: E 09.06.28 Bending removed KJ/JLM

Drawing Name : CLAMP
Part Number : D2438
Drawing Number : D2438 REV. C
Project Number : N/A
Drawing Revision : C
Material : N/A
Due Date : 2/5/2007 Qty: 300 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 2928

CFI

Laser-cut as per Dwg D2438

Material release note is required

07/01/24

300

2.0 D2438B Clamp



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)
CLAMP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2438
(6.786" center to center)

07-02-27 300

QSP019

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr any rough edges

07-03-07

P10

297

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
070227	4.0	Split this wro for Qty of 3. Out of 300, 297 to remain on this wro. For a Rush Kit.	J	070227	297	J 070227	J 070227

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070307	5.0	1 part missing. After split Qty remaining is 296.	J 070307	Parts were counted 2 times. Qty 296.	SD 07/03/07	J 070307	J 070307	J 070307

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 30381

Part Number: D2438

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 07/03/07 297

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 7/3/07 (297)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(297)

Comment: FINAL INSPECTION/W/O RELEASE

PC 07/03/07

Job Completion



V 07-03-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

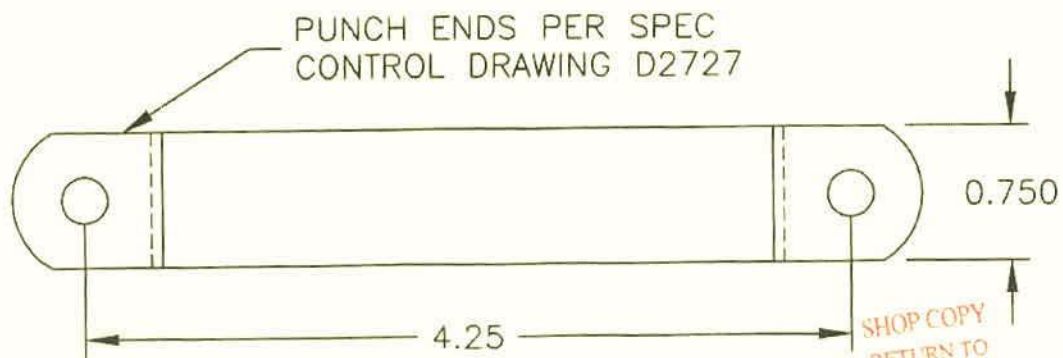
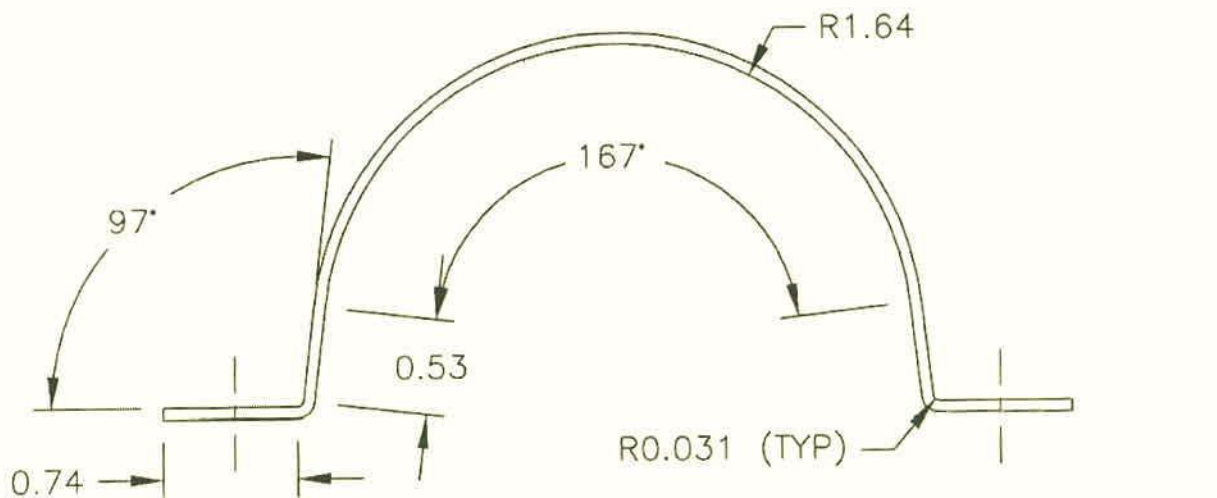
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>	APPROVED <i>KE</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
98.06.17 KE



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30381

00 06.06
CP 00 06.07

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE**



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 9 OUR JOB NO J0156617 SHIPPING MEMO 0358302

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>--</u>	<u>300 PCS</u>	<u>PO00002928</u>	<u>D2438B</u>	<u>C</u>	<u>CLAMP</u>	<u>C</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>S.S.T 304</u>		<u>SIGMA METALS</u>		<u>823772</u>		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>CONFORMS</u>
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 22 February 2007

G.F.I. Q.C. REP.

B. Samuël



Sigma Metals Inc.

45 Jeffery Blvd.

Deer Park, NY 11729

A Small Woman Owned Business

(631) 243-2100 • (800) 471-7890 • Fax: (631) 243-3426

Packaging Slip

DATE: 11/12/06

819-06

BILL TO

GFI INC.
180 AVENUE LABROSSE
POINT-CLAIRE
QUE, CANADA
H9R 1A1

SHIP TO

GFI INC.
180 AVENUE LABROSSE
POINT-CLAIRE
QUE, CANADA
H9R 1A1

P.O. NO.	TERMS	REP	SHIP VIA	FOB	SALES ORDER
0070340	Net 30	ETF	YELLOW	DEER PARK, NY	58484
ITEM	DESCRIPTION	QTY			
SS SHEET	304 A STAINLESS STEEL SHEET AMS 5513 063 X 48 X 96 85 LBS. MILL: ATI LOT #823772	1			
SKID	SKID CHARGES				
GFI INC.					
MATERIEL REQU NE SERA ACCEPTE D'APRES VERIFICATION DE DIMENSIONS, PAISSEUR, POIDS ET CONDITIONS.					
SIGNATURE: <u>[Signature]</u> DATE: <u>11 DEC 06</u>					
CERTIFICATE OF COMPLIANCE THE WILLFUL RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS ON THIS DOCUMENT MAY RESULT IN PUNISHMENT AS A FELONY UNDER FEDERAL STATUTES. THIS DOCUMENT CERTIFIES THAT ALL ITEMS NOTED ABOVE ARE IN CONFORMANCE WITH THE CONTRACT DRAWINGS, SPECIFICATIONS AND OTHER DOCUMENTATION. ALL REQUIRED PROCESS CERTIFICATION AND CHEMICAL AND PHYSICAL TEST REPORTS ARE ON FILE IN THE FACILITY AND ARE SUBJECT TO REVIEW. THIS MATERIAL MEETS ALL SPECIFICATIONS LISTED. GREG SALADINO, QC <u>[Signature]</u> <u>Greg Saladino</u> Quality Control Manager					

ORDER COMPLETE. TEST REPORTS WITH SHIPMENT.
WE NOW ACCEPT VISA, MASTERCARD, AND AMERICAN EXPRESS

NOTICE OF SHIPMENT/
PACKING LIST



AL 6168A-7 400

CERTIFICATE OF TEST

SOLD TO		FORMS DISTRIBUTION		CUST CODE		ACCEPTING MILL		SHIPPER NO.		PRODUCT CODE		MILL ORDER NUMBER		DATE SHIPPED	
1		SHIP TO		07/06/06 989720		NEW CASTLE, IN.		515336		13020102060000		30-076-559		10/10/06	
		SPEC				REPEAT ORDER		GOVT CONTRACT		MAT'L		SHIPPING LOCATION		INVOICE	
						88859-0				1121		NEW CASTLE		071326	
						PRIME SEC.									
						DSO DSO									
						583									

GRADE AND SPECIFICATIONS
 ALLEGHENY STAINLESS STEEL TYPE 304 SHEET C R COILS ANNEALED 2B FIN 3 EDGE (AMS 5513H) (AMSQQS763 COND
 ACHEM/MECH ONLY-CF) (ASME-SA-480-A05) (ASTM-A-480-06B) (ASME-SA-666 ED 2004) (DIN EN 10204:2005 3.1
 CERTIFICATE) (ASME-SA-240-A05) (ASTM-A-240-05A)

CARRIER - COORDINATORS, INC.

ITEM	PCS	DIMENSIONS W/G/L	HEAT #	COIL #	TEST #	GROSS	TARE	NET	THEO	TAG #/	CD	SKID #
001B	1	48./059/2395.	823772	09256N325	7730843	21875		21875		148333		
	1	48./059/2395.	823772	09256N332	7730843	22650		22650		148332		
P CUST IDENTITY 304.059X48												
2 COILS						44525		44525				

TYPE	HEAT/TEST	--C--	--MN--	--P--	--S--	--SI--	--CR--	--NI--	--MO--	--CU--	--N--
HEAT	823772	.06	.96	.034	.001	.41	18.28	8.07	.38	.50	.06

ITEM	TEST NO	YIELD	TENSILE	% ELONG	HARDNESS	BEND	CORROSION	GRAIN	HARDENABILITY
001B	7730843	PSI *	PSI	IN 2"	% R/A		A 262 PR E	SIZE	
		T 46900.	97000.	49.	NR	85.HRB	T PASS	NR	NR
		* Y.S. BY 0.2% OFFSET METHOD							

NR = DATA NOT REQUIRED
 GRADE VERIFICATION WAS CARRIED OUT SPECTROSCOPICALLY

PAGE 01 - CONTINUED ON PAGE 02

10/10/06 10:34:40

DISCLAIMER: Please Note: This consignment was turned over to
 in first class condition, being correctly loaded, at which time
 responsibility for loss or damage in shipment ceased. For your
 please examine shipment as it arrives. If any shortage
 is discovered, have a full description made by
 agent on waybill before signing.

Material Safety Data Sheets for this product have been
 supplied to your Purchasing Department. For an additional copy
 phone 724-226-6577. CAUTION: Processing that makes
 fumes, dust, or solutions may cause lung disease. See Material
 Safety Data Sheets for further information.

WARNING

Les fiches d'information-sécurité de ce produit ont été fournies à votre
 département chargé des achats. Pour obtenir des exemplaires supplémentaires
 veuillez téléphoner au numéro suivant 724-226-6577. Attention: les
 traitements entraînant la production de vapeurs, poussières, ou solutions
 peuvent être cause de maladies pulmonaires. Pour plus de renseignements se
 référer aux fiches d'information.

The above is a true copy of data on file. The material and test
 results conform to the sales contract and specification(s) as set
 forth in Allegheny Ludlum's Order Acknowledgement.

C. M. Napoli
 Manager, Technical Information

NOTICE OF SHIPMENT/
PACKING LIST



AL 6168A-7 400

CERTIFICATE OF TEST

SOLD TO		FORMS DISTRIBUTION		CUST. CODE		ACCEPTING MILL		SHIPPER NO.		PRODUCT CODE		MILL ORDER NUMBER		DATE SHIPPED	
1		1		07/06/06 989720		NEW CASTLE, IN.		515336		13020102060000		30-076-559		10/10/06	
				REPEAT ORDER		DO RATE		GOVT CONTRACT		MATERIAL		SHIPPING LOCATION		INVOICE	
				88859-0		38				1121 NEW CASTLE		IN		071326	
				PRIME		SEC.									
				DSO		DSO									
				583											

GRADE AND SPECIFICATIONS CARRIER - COORDINATORS, INC.
ALLEGHENY STAINLESS STEEL TYPE 304 SHEET C R COILS ANNEALED 2B FIN 3 EDGE (AMS 5513H) (AMSQQS763 CONDACHEM/MECH ONLY-CF) (ASME-SA-480-A05) (ASTM-A-480-06B) (ASME-SA-666 ED 2004) (DIN EN 10204:2005 3.1 CERTIFICATE) (ASME-SA-240-A05) (ASTM-A-240-05A)

THIS CERTIFICATE OF TEST SHALL NOT BE REPRODUCED EXCEPT IN FULL WITHOUT THE WRITTEN APPROVAL OF THE COMPANY. THE RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. MATERIAL WAS MANUFACTURED IN ACCORDANCE WITH THE ALC QUALITY MANUAL REVISION 16 DATED 08/07/2006. ALC HOLDS SEVERAL QUALITY CERTIFICATIONS THAT INCLUDE ISO-9001. DIN EN 10204:2005 - 3.1. ALLEGHENY LUDLUM IS APPROVED AS A MANUFACTURER ACCORDING TO AD-MERK BLATT WO/TRD100 AND THE PRESSURE EQUIPMENT DIRECTIVE PED 97/23/EC. TESTING WAS PERFORMED AT ALC NADCAP AND ISO/IEC 17025 APPROVED LABORATORIES LOCATED AT NATRONA HEIGHTS, BRACKENRIDGE, LATROBE, MIDLAND AND LEECHBURG PA FACILITIES OR A NADCAP AND ISO/IEC 17025 ACCREDITED LABORATORY.

ALLEGHENY LUDLUM PERFORMS CHEMICAL ANALYSIS BY THE FOLLOWING TECHNIQUES:
C,S BY COMBUSTION/INFRARED
N,O,H BY INERT FUSION/THERMAL CONDUCTIVITY
MN,P,SI,CR,NI,MO,CU,CB,CO,V BY WDXRF
B BY OES
AL AND TI (>=0.10%) BY WDXRF, OTHERWISE BY OES
PB,BI,AG BY GFAA

SIGMA METALS INC.

THESE TEST REPORTS APPLY TO:

QFI
P.O. 0070340
S/O 58484
PCS. 1
NET 85#
FIG
DATE 12-7-06

PAGE 02 - FINAL PAGE.

10/10/06 10:34:40

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C. M. Napoli
Manager, Technical Information

